

Date: Thursday, 6/28/2007 9:50:59 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD  
Job Number : 33244 - 2  
Estimate Number : 12782  
P.O. Number : NA Part Number : D35643  
This Issue : 6/28/2007 S.O. No. : N/A Drawing Number : D3564 UNDER REVIEW  
Prsht Rev. : NC Project Number : N/A  
First Issue : 6/28/2007 Type : SMALL /MED FAB Drawing Revision : K C PH 07-07-19  
Previous Run : 31419 Material :  
Written By : Due Date : 7/10/2007 Qty: 20 Um: Each  
Checked & Approved By : Star 07.06.28  
Comment : Est Rev: A New Issue 07-03-08 ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.9177 sf(s)/Unit Total: 18.3540 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: M 10B 873 IB 07-07-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\*

Dwg Rev: CProg Rev: C

2-Deburr if necessary

IB 07-07-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

counted  
07/07/19 (20)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT 1179 and DT 9155

Form Joggle as per Dwg D3564 on brake using Jig DT8157

07/07/19 (20)07/07/19 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 27/07/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 6/28/2007 9:50:59 AM

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Drawing Name: WEARPAD

Job Number: 33244

Part Number: D35643

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

*Can on 07/07/20 (X21) (center)*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R

2059B Hardcoat

*1104463*

Weld hardcoat as per Dwg D3437

*FC 07/07/23*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*11/07/23 (21)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*11/07/23 (21)*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M 104846**BR/m/07-07-25 (50)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*P-7/7/25 (24)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*F-P-14**M.L 07/07/25**(21X)*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(21) 07/07/25*

Job Completion

*Good 07-07-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

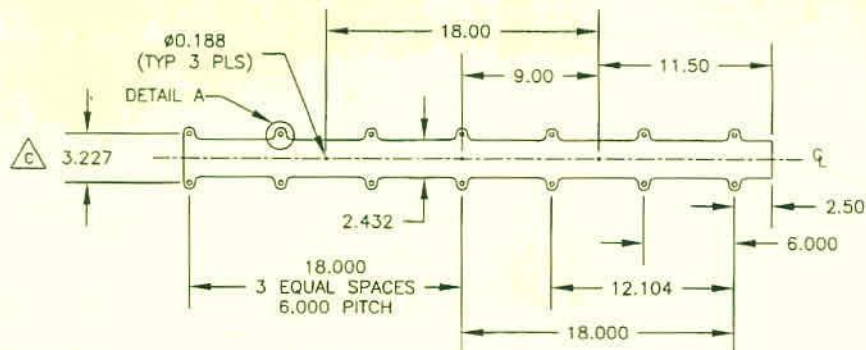
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

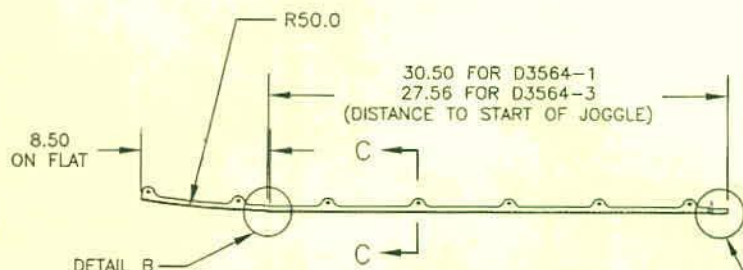
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

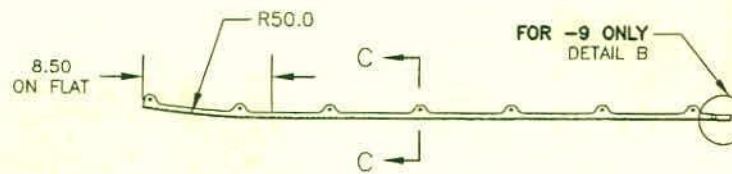




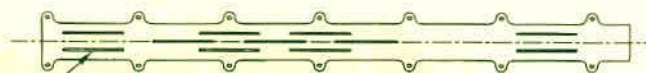
D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-1/-3/-9/-11 WELDING DETAIL

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

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**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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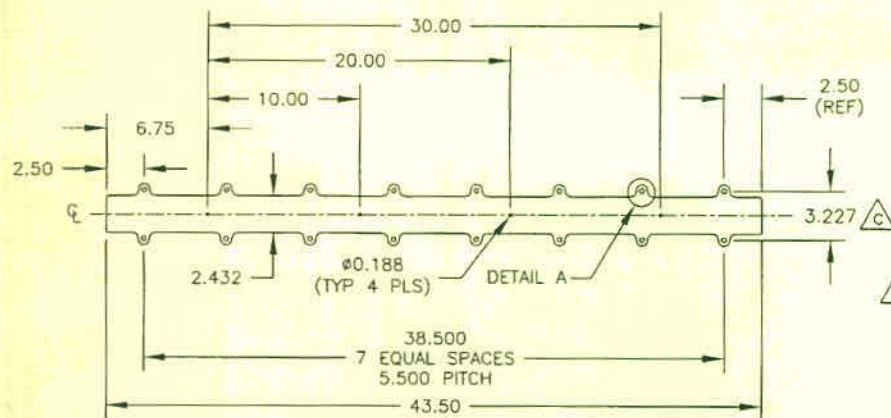
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, OXFORD, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE	07.04.17	TITLE WEARSHOE
		REV. C SHEET 1 OF 2 SCALE 1:5

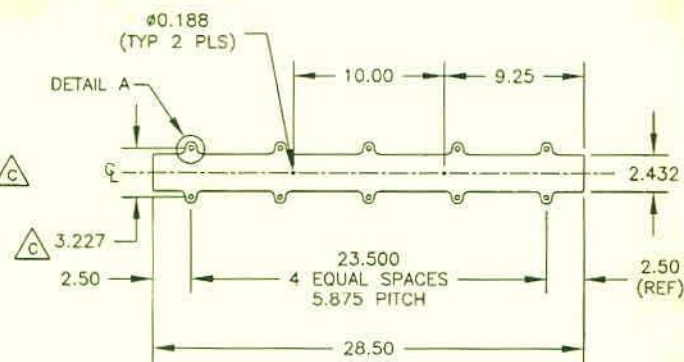
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07.06.28



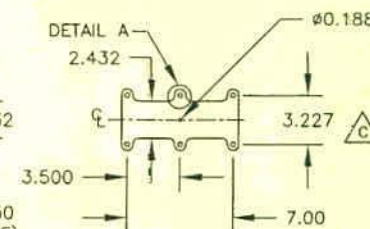




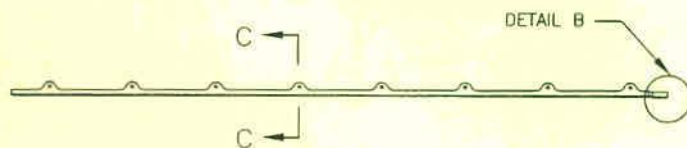
**D3564-5F FLAT PATTERN**



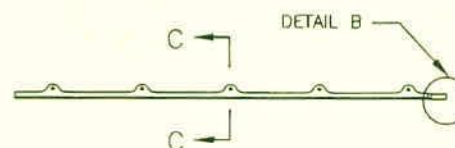
**D3564-7F FLAT PATTERN**



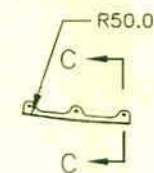
**D3564-13F FLAT PATTERN**



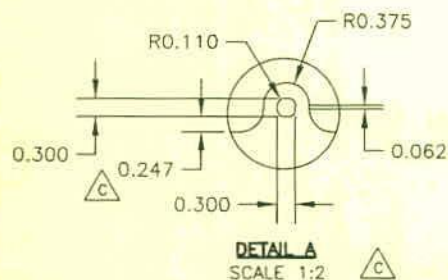
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



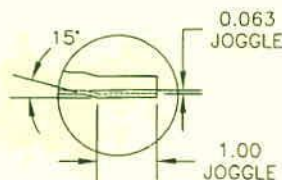
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

**RELEASED**  
07.04.17

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DATE		D3564	REV. C
07.04.17		TITLE	SHEET 2 OF 2
		WEARSHOE	SCALE
			1:8







